

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claims 1-24 (canceled).

Claim 25. (currently amended) An apparatus for producing consumable products having an outer shell comprising:

a mold containing a consumable material;  
a water-cooled ram having an axial bore;  
the water-cooled ram is configured to selectively move into and out of the mold between a first position and a second position for at least partially forming an outer shell from the consumable material;

a displacement ram movably mounted within the axial bore of the water-cooled ram; and

the displacement ram is configured to selectively move within the axial bore of the water-cooled ram and into and out of the mold between a first position and a second position to contact the at least partially formed outer shell of consumable material to expel air inclusions therefrom when the water-cooled ram is in the second position.

Claim 26. (currently amended) An apparatus for producing consumable products having an outer shell comprising:

a mold containing a consumable material;  
a water-cooled ram having an axial bore;  
the water-cooled ram is configured to selectively move into

and out of the mold between a first position and a second position for at least partially forming an outer shell from the consumable material;

a tube located within the axial bore and communicating with the mold;

a source of gas connected to the tube; and

the gas from the source communicates through the tube and into the mold for displacing an amount of consumable material when the water-cooled ram is in the second position.

Claim 27. (currently amended) An apparatus for producing consumable products having an outer shell comprising:

a mold;

a water-cooled ram comprising an internal space and a flexible sheath surrounding the internal space;

the water-cooled ram is configured to selectively move into and out of the mold between a first position and a second position for at least partially forming an outer shell from the consumable material;

a source of cooling water under pressure; and

the cooling water under pressure communicates with the internal space of the water-cooled ram to expand the flexible sheath within the mold for displacing an amount of consumable material when the water-cooled ram is in the second position.

Claim 28. (currently amended) An apparatus for producing consumable products having an outer shell comprising:

a mold;

a water-cooled ram comprising an internal space and a shell of rigid material surrounding the internal space, the shell is provided with a passage which communicates the internal space with

the mold when the water-cooled ram is located in the mold, said passage is covered by a diaphragm;

the water-cooled ram is configured to selectively move into and out of the mold between a first position and a second position for at least partially forming an outer shell from the consumable material;

a source of cooling water under pressure; and

the cooling water under pressure communicates with the internal space of the water-cooled ram for expanding the diaphragm into the mold for displacing an amount of consumable material when the water-cooled ram is in the second position.